

Work Order ID 52608

October 3, 2009 12:40:33 PM



Page 1

Item ID: PB67-43001-229

Accept



Setup Start



Revision ID: C

Item Name: Outer Tube

Stop



Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/07/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: 09-10-03 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
B67-43001	C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

1- cut to length and cut angle on one end of tube as per dwg
2- deburr

AP 09-10-7

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

1- drill holes and mill slot as per dwg PB67-43001
2- deburr

AP 09-10-7 (2)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

⇒ Sorlolo3



f

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld end cap as per dwg PB67-43001
2- grind weld flush

Cpl 09 10 07

140

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

27 502/10/08

⑫

150

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

27 502/10/08

⑫

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Page 3

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Setup Start



Revision ID: C

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Start Date: 10/05/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/07/2009 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location:

Cpl

0.00



Packaging

Memo

0.00

Packaging

Cpl 09 10 13

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/14 *[Signature]*
MF 09-10-13

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

October 3, 2009 12:40:33 PM

Page 1

Work Order ID: 52608

Parent Item: PB67-43001-229RevB1

Parent Item Name: Outer Tube

Comments:

Start Date: 10/05/2009

Required Date: 10/07/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6T1.750W.065		Purchased	No			100	f	83.4000	10.7895			
6061T6 RDTUBE 1.750 X 0.65W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

83.4

108551

2.24

109397

4.47

110885

16.69

111432

60

130

Each

9.0000

2.0000

PB67-43001-233RevB1

Manufactured No

Outer Tube End Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

41573

9

PO 10.7

10.25

lpl 09-10-07

(2) lpl ✓

W/O:		WORK ORDER CHANGES					
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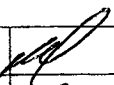
DART AEROSPACE LTD		Work Order: 52608
Description: OUTER TUBE		Part Number: B67-43001-229
Inspection Dwg: B67-4301-Rev: C		Page 1 of 1

229

FIRST ARTICLE INSPECTION CHECKLIST

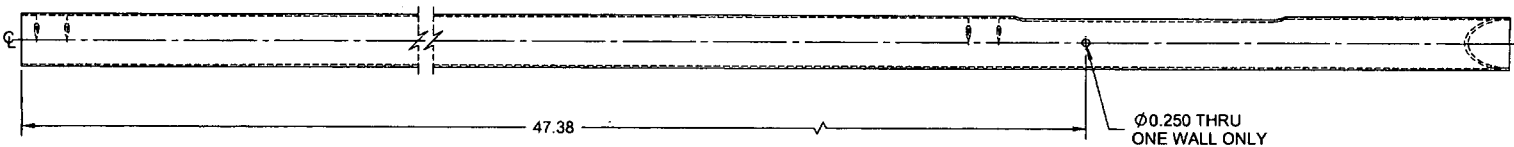
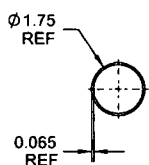
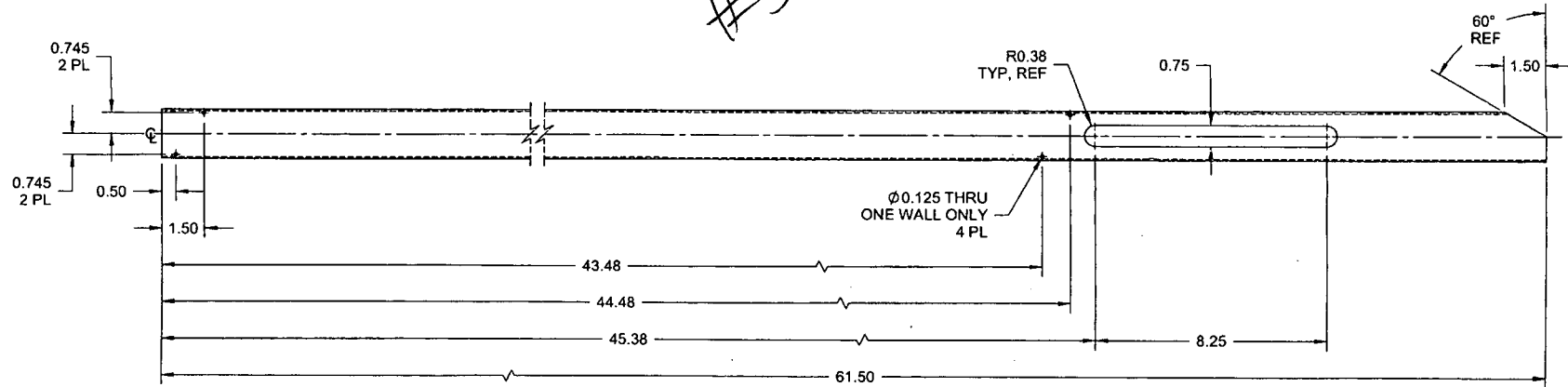
☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.75 2pl	+/- .010	.745	✓			
.75 2pl	+/- .010	.745	✓			
.50	+/- .030	.50	✓			
1.50	+/- .030	1.50	✓			
43.48	+/- .030	43.48	✓			
44.48	+/- .030	44.48	✓			
45.38	+/- .030	45.38	✓			
8.25	+/- .030	8.25	✓			
61.50	+/- .030	61.50	✓			
R.38	+/- .030	R.38	✓			
.75	+/- .030	.75	✓			
60°	+/- 1/2°	60°	✓			
1.50	+/- .030	1.50	✓			
1.75	+/- .030	1.75	✓			
.065	+/- .010	.065	✓			
47.38	+/- .030	47.38	✓			
.250 Ø	+1.006 - 1.001	.250	✓			

Measured by: 	Audited by: S	Prototype Approval:	N/A
Date: 09.10.7	Date: 09/10/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

#52008



B67-43001-229 OUTER TUBE

RELEASED
2009-09-24
MP

- NOTES:
- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING
PER WW-T-700/6 OR AMS4080 OR AMS 4082 OR
AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF. DART SPEC. M6061T6T1.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.00 lbs

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 19 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.02.27
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	AS			
CHECKED	AS	DRAWING NO.	REV. C	
MFG. APPR.	AS	B67-43001-229		SHEET 1 OF 1
APPROVED	AS	TITLE	SCALE	
DE APPR.	N/A	OUTER TUBE		NTS
DATE	09.02.27		<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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